

FIG. 1

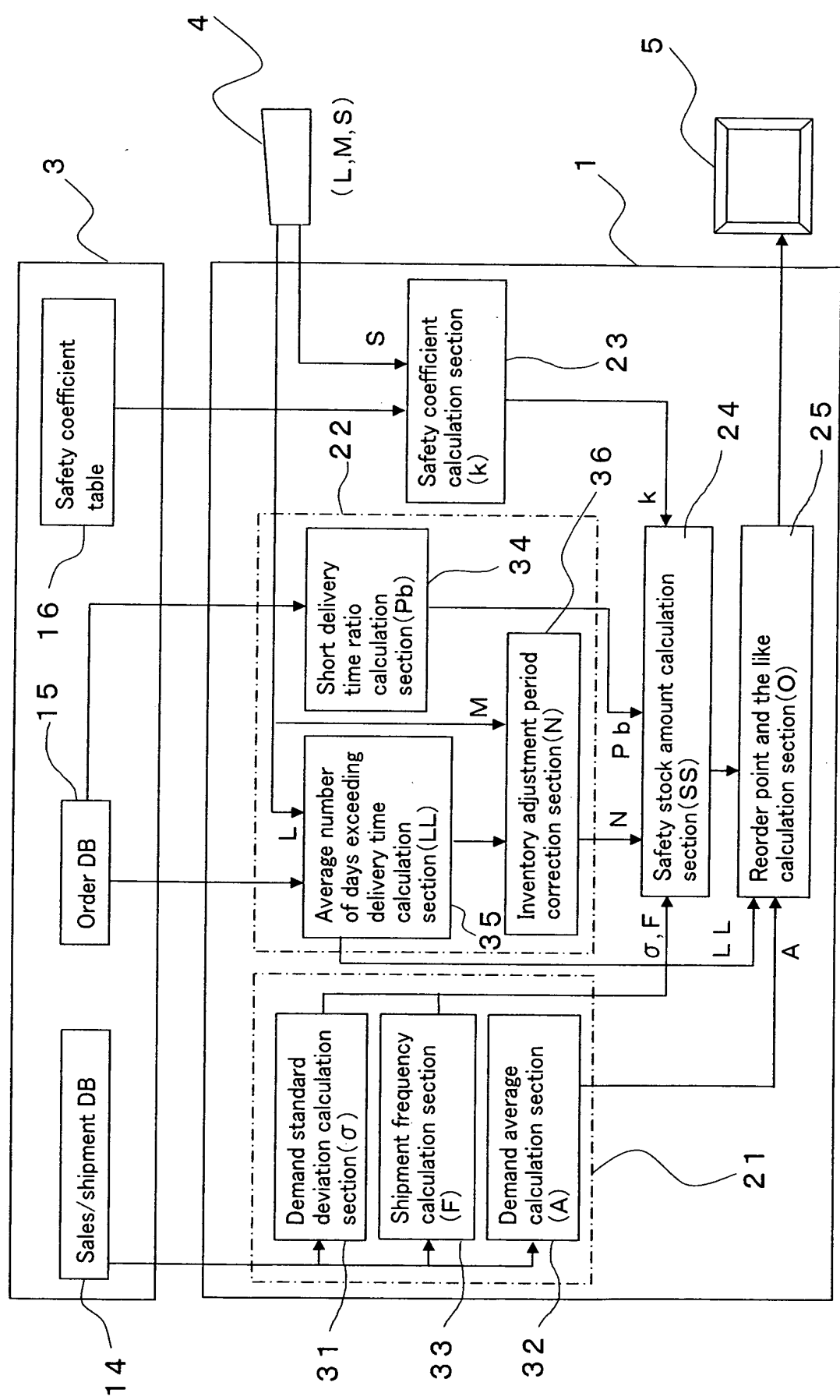


FIG. 2

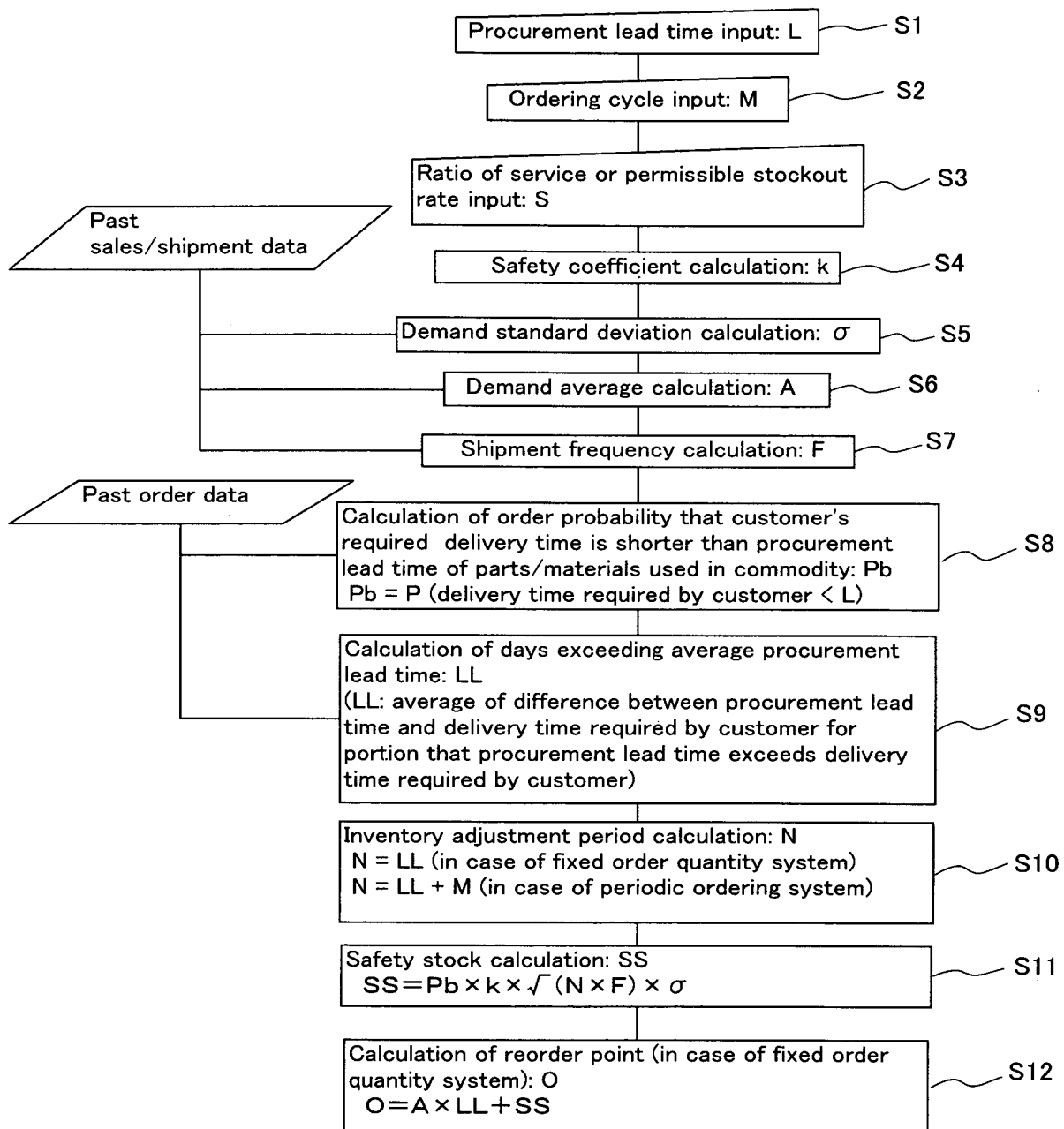


FIG. 3

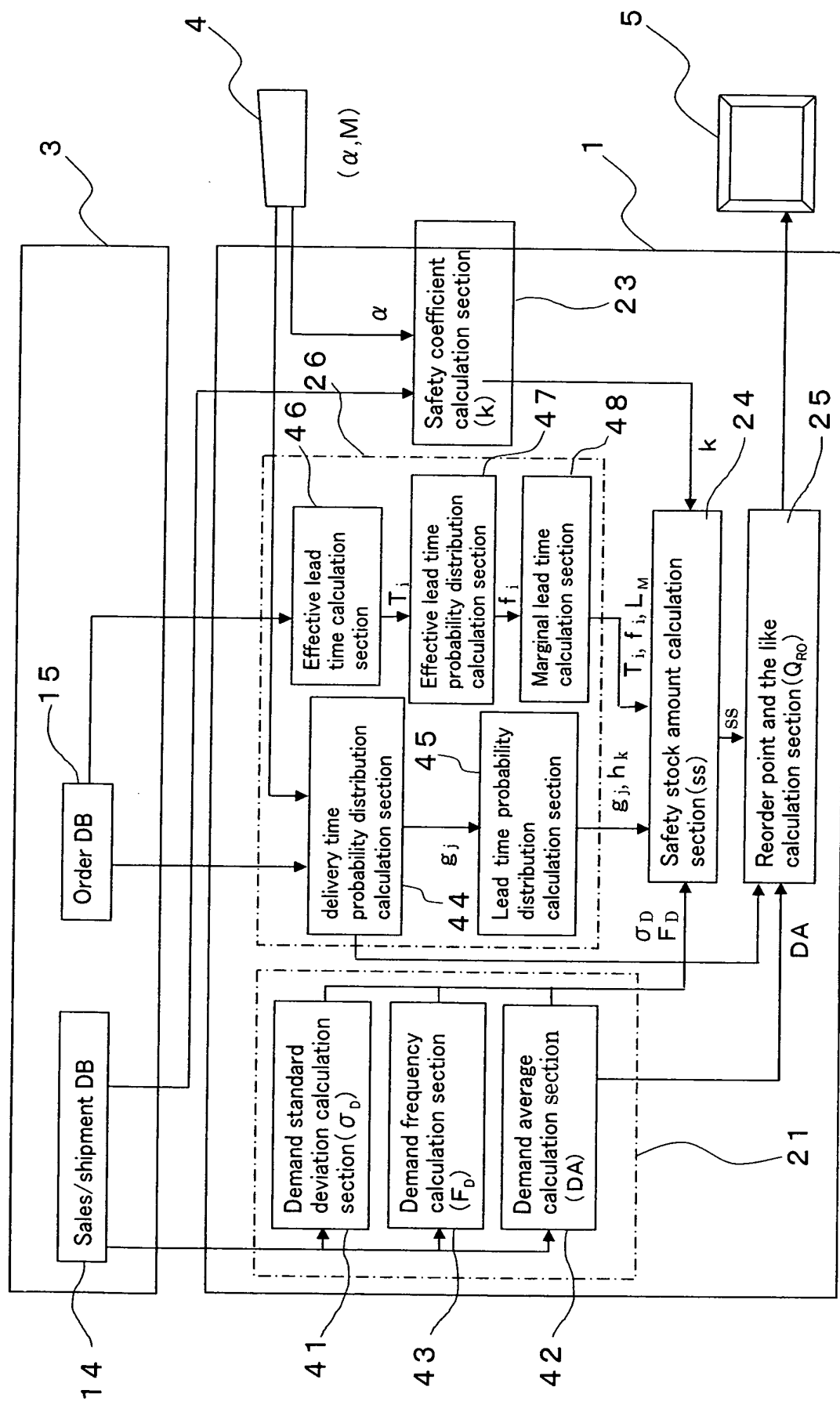


FIG. 4

FIG. 5

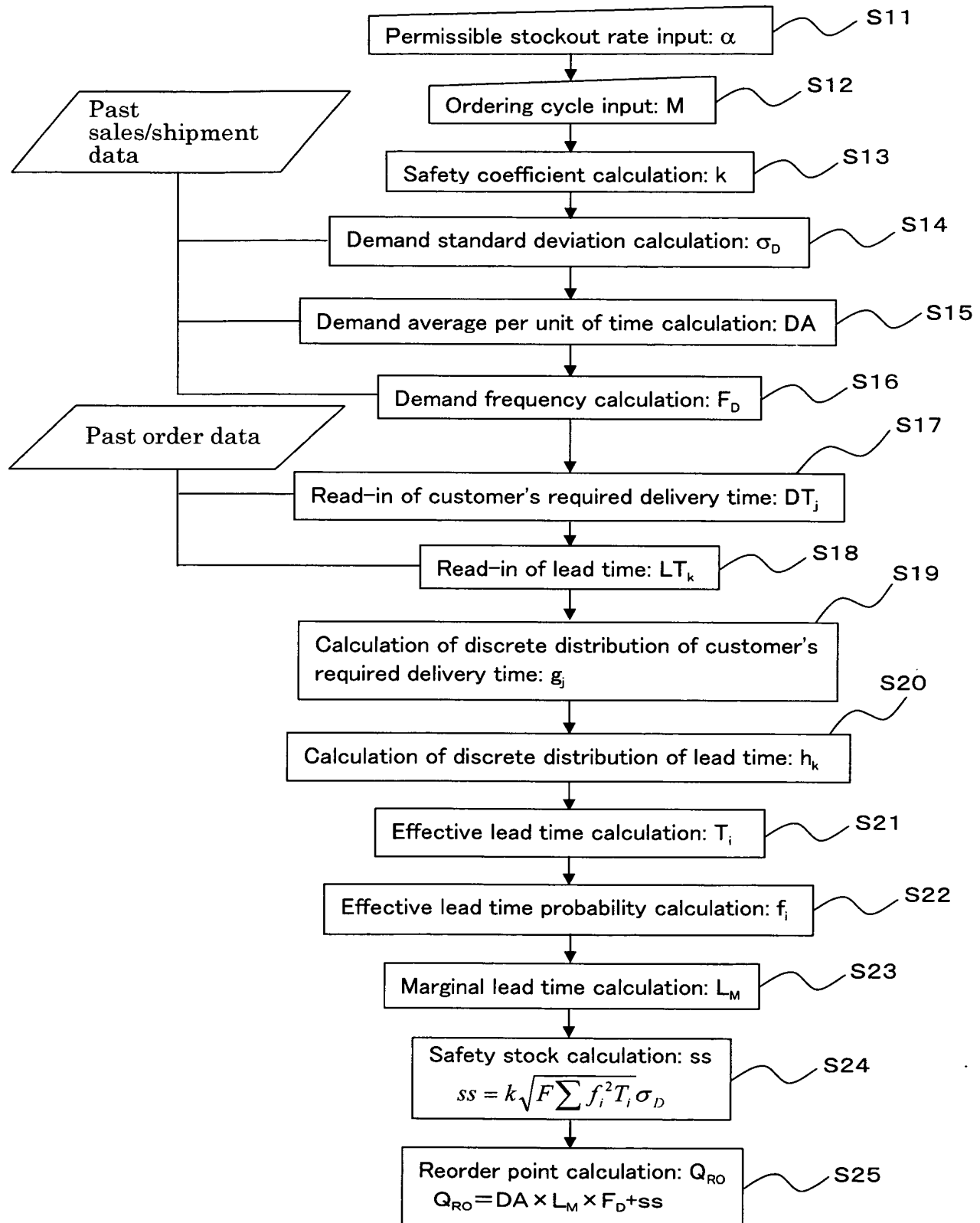


FIG. 6

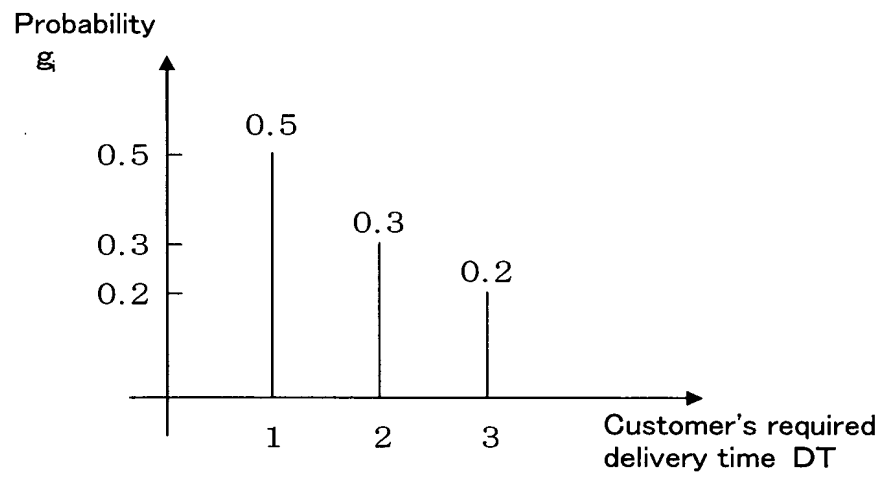


FIG. 7

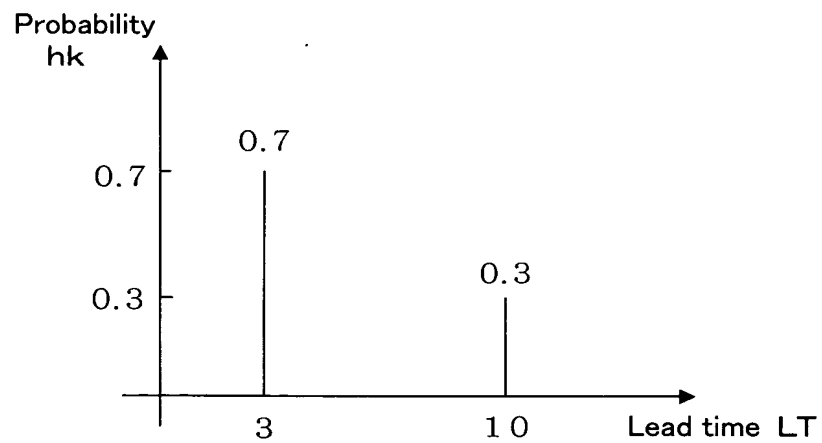


FIG. 8

Customer's required delivery time		Lead time		Effective lead time	
D T	g_j	L T	h_k	T_i	f_i
1	0.5	3	0.7	2	$0.5 \times 0.7 = 0.35$
1	0.5	10	0.3	9	$0.5 \times 0.3 = 0.15$
2	0.3	3	0.7	1	$0.3 \times 0.7 = 0.21$
2	0.3	10	0.3	8	$0.3 \times 0.3 = 0.09$
3	0.2	3	0.7	0	$0.2 \times 0.7 = 0.14$
3	0.2	10	0.3	7	$0.2 \times 0.3 = 0.06$

$$T_i = L T_k - D T_j \quad (L T_k > D T_j)$$

$$T_i = 0 \quad (L T_k \leq D T_j)$$

FIG. 9

i	T_i	f_i	$f_i^2 \cdot T_i$	f_i Cumulative total
1	0	0.14	0	0.14
2	1	0.21	0.0441	0.35
3	2	0.35	0.245	0.70
4	7	0.06	0.0252	0.76
5	8	0.09	0.0648	0.85
6	9	0.15	0.2025	1.00
Total			0.5816	